

5116

| | | |
|------------------------------------|--------------|---------|
| DART AEROSPACE LTD | Work Order: | 23060 |
| Description: Step (casting detail) | Part Number: | D2576-3 |
| Dwg: D2576 Rev. E | Qty: | 104 |

| Step | Location | Procedure | By | Date | Qty |
|------|----------|--|-----------|----------|-----|
| 1 | DC | Issue Traveller <i>Dwg not required. RF 03.01.15</i> | <i>KJ</i> | 05.04.12 | 104 |
| 2 | PG | Issue P/O: <i>P/O No: 2011368</i> Cast per D2576 Pattern Material Release Note Required <i>Nosth</i> | <i>U</i> | 05.01.30 | 100 |
| 3 | PG | Ship D2576 mould to vendor | <i>U</i> | 05.01.30 | 1 |
| 4 | RG | Inspect for transit damage Ensure D2576 mould is returned with the ordered parts Ensure release note attached | <i>CJ</i> | 05/04/12 | 104 |
| 5 | QC6 | Inspect dimensional check | <i>J</i> | 05.10.11 | 104 |
| 6 | MV | Machine per folio D2576-3 FA332 & Dwg. D2576 | <i>En</i> | 06/06/11 | 104 |
| 7 | MV | Deburr | <i>En</i> | 06/06/11 | 104 |
| 8 | QC5 | Inspect for Completeness of W/O | <i>J</i> | 06.06.12 | 103 |
| 9 | LG | Identify and Stock | <i>BE</i> | 06-06-12 | 103 |
| 10 | AC | Job Cost/Part | <i>U</i> | 06.06.12 | 103 |
| 11 | DC | Close W/O Inspect Level 21 | <i>ND</i> | 06/06/12 | 103 |

| Rev | Date | Change | Revised By | Approved |
|-----|----------|---|------------|----------|
| A | 96.08.20 | New Issue | | |
| B | 98.10.15 | Now goes on HAAS | KS | |
| C | 99.09.13 | Change Dwg to rev.E | EC | |
| D | 00.09.05 | Changed part number to D2576-3 for machining detail | EC | |
| E | 02.08.19 | Consolidated D2576-1 and D2576-3 | KJ RF | <i>J</i> |

RELEASED
02/08/19 RF

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: 23060 | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------------|------|---|-----------------------------|----------------------------------|------------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| 060612 | 6 | 1 part too thin. machined crooked, was flat in use. | | scrap: destroy | J.L. 06/06/12 | 060612. | 060612 | 060612 |
| | | | | | | | | |
| | | | | | | | | |

Part No: D2576-3 PAR #: W/A Fault Category: Prod / Machine ^{parts} NCR: Yes No DQA: Date: 06/06/12

NOTE: Date & initial all entries QA: N/C Closed: Date: 06.06.13

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 12, 2005
02:25 pm

Work Order No : 0023060
Project Name : D2576-3
Project For : WK516
Work Order Type : Main
Main WO Number :
House Part Number : D2576-3
Description : Step (Machining Detail)
Manufactured : Yes
Amount Req'd : 104
Amount Done : 0
Start Date : 04-12-05
Est Finish Date : 04-22-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

| | Estimated | Actual | Var. % | Posted | To Post |
|---------------------|-----------|--------|--------|--------|---------|
| Material Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Engineering Hours : | 0.00 | 0.00 | 0.00 | | |
| Engineering Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Production Hours : | 0.00 | 0.00 | 0.00 | | |
| Production Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Packaging Hours : | 0.00 | 0.00 | 0.00 | | |
| Packaging Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| OverHead Hours : | 0.00 | 0.00 | 0.00 | | |
| OverHead Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| CNC Hours : | 0.00 | 0.00 | 0.00 | | |
| CNC : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Misc. Hours : | 0.00 | 0.00 | 0.00 | | |
| Misc. : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Burden : | 0.00 | 0.00 | 0.00 | | |
| Total Cost : | 0.00 | 0.00 | 0.00 | | |
| Mark up : | 0.000 | 0.000 | | | |
| Selling Cost : | 0.00 | 0.00 | | | |

| | Estimated | Actual |
|--------------------------|-----------|--------|
| Labour Hrs/Amount Done : | 0.00 | 0.00 |
| Profits/(Loss) : | 0.00 | 0.00 |

CERTIFICATE OF ANALYSIS

CUSTOM ALLOY LIGHT METALS
13329 ECTOR STREET CITY OF INDUSTRY, CA 91746
PH# (626) 369-3641 FAX# (626) 369-2471

CUSTOMER:

RYPAC ALUMINUM
11849 TANNERY ROAD
SURREY BRITISH COLUMBIA,

SHIP DATE **AUG 30 2004**

Alloy: 535.2

Heat: G513

| | |
|-----|-----------|
| Si | 0.031 |
| Fe | 0.090 |
| Cu | 0.003 |
| Mn | 0.171 |
| Mg | 7.170 |
| Cr | 0.001 |
| Zn | 0.007 |
| Ti | 0.170 |
| Sn | 0.002 |
| Pb | 0.001 |
| Ni | 0.001 |
| OET | < .15 |
| Sr | 0.000 |
| Al | REMAINDER |

| | |
|-----|-----------|
| Si | .10 |
| Fe | .10 |
| Cu | .05 |
| Mn | .10-.25 |
| Mg | 6.6-7.5 |
| Cr | |
| Zn | .05 |
| Ti | .10-.25 |
| Sn | |
| Pb | |
| Ni | |
| OET | .15 |
| Sr | |
| Al | REMAINDER |

BE .004

BE .003-.007

ELEMENTS LISTED WITHOUT A RANGE, UNDER THE REQUIRED SPECIFICATIONS, ARE MAXIMUM ALLOWABLE PERCENTAGES. SAMPLES ANALYZED ON AN OPTICAL EMISSION SPECTROMETER WITH CURRENT CALIBRATION STATUS. STANDARDS ARE NIST OR ARE TRACEABLE TO NIST.


RON ZAKRZEWSKI

AUG 30 2004
DATE

LAB MANAGER

FM-12.01 Rev D 12/5/2001

WARNING: THE BUYER IS ADVISED THAT THIS METAL MAY CONTAIN CREVICES AND HIDDEN RECESSES HOLDING ENTRAPPED MOISTURE. THE METAL SHOULD BE HANDLED AND PROCESSED WITH THIS POSSIBILITY IN MIND. ENTRAPPED MOISTURE MAY CAUSE AN EXPLOSION IF THE METAL IS INTRODUCED INTO A MELTING FURNACE WITHOUT PROPER DRYING.